

Work Order ID 151929

Friday, October 14, 2016 1:55:30 PM

151929

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Item ID: D2596 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Web, 205 Skidtube
Start Date: 10/11/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: **DAS** Date: **OCT 17 2016** Pooling: Date: Run Start ***NR1***
QC: **21** Date: SPC (Y/N): Date: Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2596	Rev D								

100

100

Skidtube

Skidtube

Skidtube

Memo

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

0.00

0.13

110

110

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.13

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.01

DAS
03
9-89**(x4)****201701/23**
BEB**(4)** **17-1-23**

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Start Date: 10/11/2016 Start Qty: 4.00 ***4*** Cust Item ID:
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: L6002	0.00	DAS 03 9-89	(4)	DP	17-1-23			
130									
Packaging	Memo	0.01							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.07							
Quality Control									

**DAS
21
9-89** JAN 23 2017

JAN 23 2017

Picklist Print

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Work Order ID: 151929

151929

Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 10/11/2016

Required Date: 10/14/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	163.0000	1	4			

D2500-3-100

Ext'n -1" Beam Web 4"

16-12-12 DT

Location

Loc Qty

Loc Code

LG

163

147804

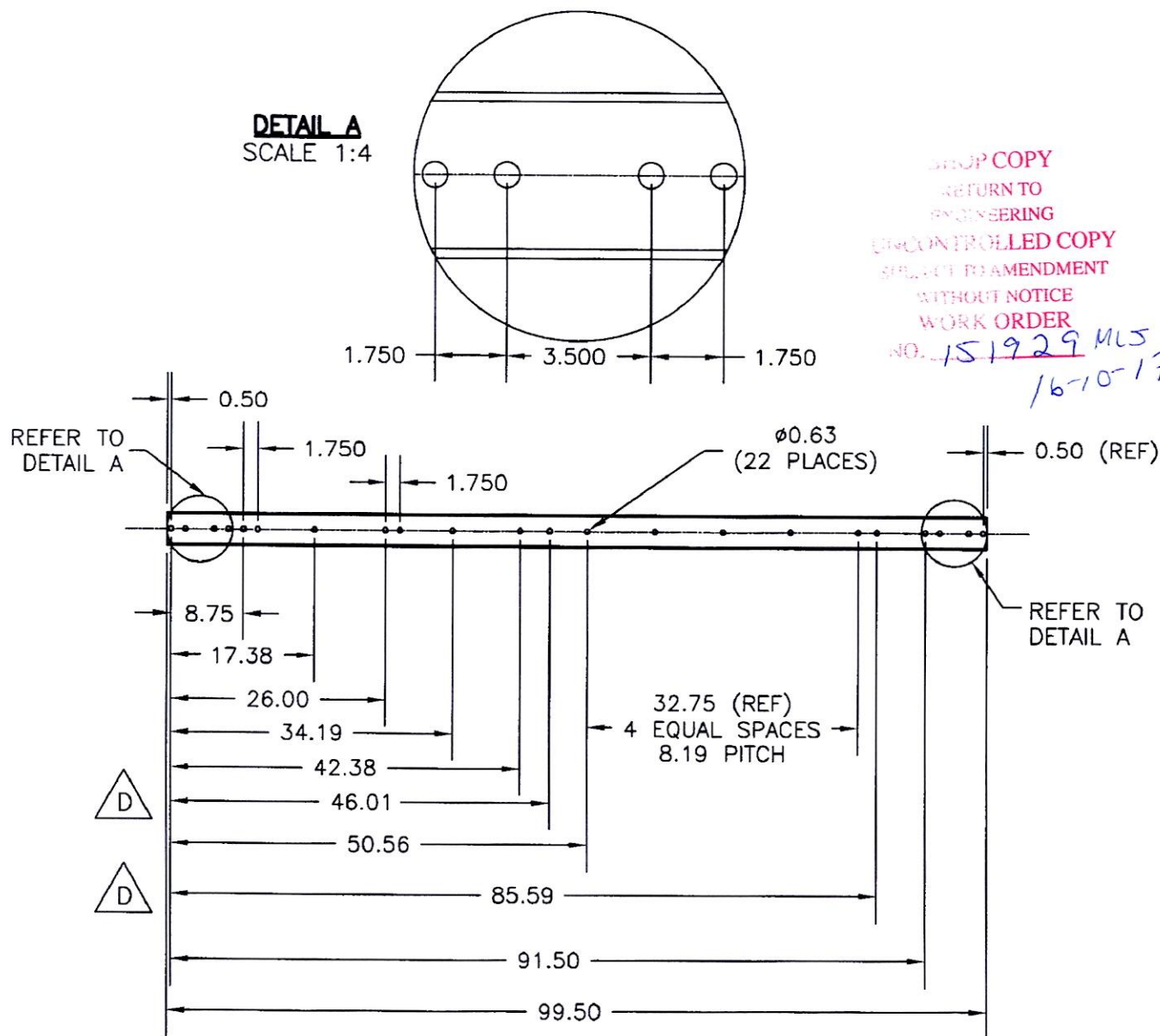
163

4

RELEASED
07 Dec 68

STOP COPY
 RETURN TO
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 151929 M

29 MLS
16-10-17



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN	PA	DRAWN BY	GH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	GH	APPROVED	GH	DRAWING NO.	REV. D
DATE	07.04.17	TITLE	205 WEB	D2596	SHEET 1 OF 1
A	96.09.16	NEW ISSUE			SCALE 1:20
B	97.07.23	Ø0.63 HOLE WAS Ø0.56			
C	98.09.14	INCORPORATED DEO 9097			
D	07.04.17	INCORPORATED DEO 9183			

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QA:

Date: 2017-02-22



QA Closed:

Date:

JAN 31 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: 151929 Part No. D2596 NCR No. 17-62416		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☒ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐							
Date: 17/1/3		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				DAS 12 9-89 17/1/3 Completed By			
Boring tool slipped and partially cut tube. One 1/8" aft saddle hole was partially cut by 1/8" approx, cut through half of webbing.				Blend out. Acceptable. No effect on strength of I-beam, webbing provides little strength.				DAS 12 9-89 17/1/3 Lead hand / Supervisor Approval Verification			
								DAS 9 9-89 17-01-25 QC / QA Coordinator Approval			
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☒ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☒ Misaligned/off center ☐ Turning Sequence ☐						OTHER :	